



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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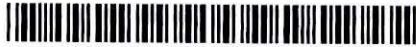
D4812-041
Job Sheet 179539



Part No: D4812-041

Job Qty: 5 ea

Part Name: Patient Stop Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM IPP REV:B 16.04.19 AS PER DWG REV.B VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	7/10/18	7/10/18	0.00	0.00	Start Up Waterjet		SC 18/06/24
100	Waterjet	5 pcs	7/10/18	7/10/18	0.00	1.33	Waterjet1		SC 18/06/24
110	QC	5 pcs	7/10/18	7/10/18	0.00	0.00	QC2 Waterjet-1		SC 18/06/24
120	QC	5 pcs	7/10/18	7/10/18	0.00	0.00	QC8-5		38
130	Small Fab	5 pcs	7/10/18	7/10/18	0.08	1.33	Small Fab-7		SB 9-88 DAS
140	QC	5 pcs	7/10/18	7/10/18	0.00	0.00	QC5		38
150	HandFinish	5 pcs	7/10/18	7/10/18	0.00	0.58	HandFinish1		SA 18-07-11
160	QC	5 pcs	7/10/18	7/10/18	0.00	0.00	QC7-4		BL 18-7-12
170	Powdercoat	5 pcs	7/10/18	7/10/18	0.00	0.42	Powdercoat1		BD 18-7-12
180	QC	5 pcs	7/10/18	7/10/18	0.00	0.00	QC3		38
190	Small Fab	5 pcs	7/10/18	7/10/18	0.00	1.33	Small Fab-7		38
200	QC	5 pcs	7/10/18	7/10/18	0.00	0.00	QC5		38
210	Packaging	5 pcs	7/10/18	7/10/18	0.00	0.00	Packaging3-2	5/258	JUL 24 2018
220	QC21-SA	5 Ea	7/10/18	7/10/18	0.00	0.00	QC21		DAS 21 3-88 JUL 24 2018

1138839 START: 11:45 OUT: 3:00 FINISH: 12:15

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	10.1500 sf (2.03 ea)	90-Start up Operation	
D2690-6	Lanyard	10 Ea (2 ea)	190-Small Fab	5081355 9X 5091393 in
D4811-1	Pin, Quick Release	10 Ea (2 ea)	190-Small Fab	5038458
MS21042L3	Nut	10 Ea (2 ea)	190-Small Fab	5078167
MS27039-1-07	Screw	10 Ea (2 ea)	190-Small Fab	5079112
NAS1149D0332J	Washer	30 Ea (6 ea)	190-Small Fab	5035396

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	10	317	0
190-Small Fab	D2690-6	10	29	0
	D4811-1	10	4	0
	MS21042L3	10	1,478	0
	MS27039-1-07	10	98	0
	NAS1149D0332J	30	1,710	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Water Jet			
NCR No. _____		Engineering			
Date: _____		Quality			
Step #: _____		Other			
Description Work Order Disposition		MRB (QS1042) Approval			
DISPOSITION		Completed By			
Suspected Unapproved		Lead hand / Supervisor Approval Verification			
Rework		QC / QA Coordinator Approval			
Scrap		Dart Aerospace Ltd.			
Use-as-is		1270 Aberdeen Street			
Use-as-is		Hawkesbury, ON K6A 1K7			
Use-as-is		CANADA			
Use-as-is		TEL.: 1 613 632-5200			
Use-as-is		Email: sales@dartaero.com			
Use-as-is		www.dartaerospace.com			
Use-as-is		Container No: S083602			
Use-as-is		Part: D4812-041			
Use-as-is		Job No: 179539			
Use-as-is		Serial No/Batch: S083602			
Use-as-is		Revision:			
Use-as-is		Inspector:			
Use-as-is		Exp Date:			
Use-as-is		Instructions:			
Use-as-is		Date: 06/25/18			
Use-as-is		Positioned Wrong			
Use-as-is		Outside Dimensions			
Use-as-is		Over/Under tolerance			
Use-as-is		Part Incorrect			
Use-as-is		Part Lost/Missing			
Use-as-is		Part Moved			
Use-as-is		Drawing			
Use-as-is		Finish			
Use-as-is		Misread			
Use-as-is		Turning Sequence			
Use-as-is		Out of Sequence			
Use-as-is		Off-set			
Use-as-is		Misaligned			
Use-as-is		Fit/Function			
Use-as-is		Misaligned/off center			
Use-as-is		Countersink			
Use-as-is		Cut Too Short			
Use-as-is		Instructions Incomplete/Unclear			
Use-as-is		Drill Holes			
Use-as-is		OTHER :			
Use-as-is		OTHER :			

Root Cause	
Environment	No Re-verification
Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

Part Specifications

Specifications could not be found.

Plex 6/20/18 8:30 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	179539
Description: Patient Stop		Part Number:	D4812-041
Inspection Dwg: D4812 Rev: B		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	Ø0.191	1		VSC-01	
Ø0.250	+0.005/-0.001	Ø0.250	1		Tape	
Ø1.06	+0.012/-0.001	Ø1.06	1			
7.50	+/-0.030	7.504	1			
8.94	+/-0.030	8.945	1			
9.13	+/-0.030	9.132	1			
1.00	+/-0.030	1.00	1			
3.50	+/-0.030	3.501	1			
12.50	+/-0.030	12.50	1			
0.50	+/-0.030	0.50	1			
10.00	+/-0.030	10.004	1			
8.00	+/-0.030	8.00	1			
0.94	+/-0.030	0.942	1			
2.00	+/-0.030	2.00	1			
4.00	+/-0.030	4.00	1			
2.50	+/-0.030	2.505	1			
2.50	+/-0.030	2.502	1			
4.00	+/-0.030	4.00	1			
0.771	+/-0.010	0.770	1			
1.763	+/-0.010	1.762	1			
4.750	+/-0.010	4.750	1			
32.0	+/-0.100	32	1			
5.00	+/-0.030	5.00	1			
1.00	+/-0.030	1.00	1			

Measured by:	SC	Checked by:	DAS 38	QC Inspector:	
Date:	16/06/24	Date:	JUN 25 2018	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	
B	16.06.24	Dwg Rev updated	KJ	